

Work Order ID 66228 -1 *Split*

February 8, 2011 8:43:03 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4154-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly

Start Date: 2/08/11 Start Qty: 4.00

Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: *CL*

Date: 11/02/08 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4154

A

100

0.00



Large Fab

Memo

0.00

Large Fab

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154

2059 B Hardcoat Welding Rod

BATCH #: *M147189*

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154

304 S.S. Welding Rod

BATCH #: *M107051*

3-Transfer drill holes in bar

4- Use DT9684 to check fit after welding

110

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

CL 11-4-7 (X2)
QC 11-04-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66228

February 8, 2011 8:43:03 AM



Page 2

Item ID: D4154-041

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

Subtotal



QC

Memo

0.00

Quality Control

(42)

130

Grey Sandtex(Ref:4.3.5 6) per QSI005 4.3

0.00



Powdercoat

M 115108

Memo

0.00

Powder Coating

START TIME: *4:20*

OVEN TEMPERATURE: *320°*

FINISH TIME: *4:50*

2 11-4-7

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

ET 11-04-08 (42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66228

February 8, 2011 8:43:03 AM



Page 3

Item ID: D4154-041

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Item Name: Wearplate Assembly

Start Date: 2/08/11 Start Qty: 4.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00



Small Fab

Memo

0.00

1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3
dwg D4154.

Rockguard Black 4715

M116210

11/04/08

160

0.00



QC

QC14 - Inspect part completeness to step on W/O

Memo

0.00

11-04-08 (x2)

Quality Control

170

0.00



Packaging

Identify as per dwg & Stock Location: Finishing

Memo

0.00

11 04 08 (2)

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66228

February 8, 2011 8:43:03 AM



Page 4

Item ID: D4154-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly

Start Date: 2/08/11 Start Qty: 4.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/8 *[Signature]*

111-04-8
(2)

POSITIVE RECALL

EFFECTIVE

11-04-11

AUTH

RELEASED

11-04-13

DATE

REV. B

REV. B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 8, 2011 8:43:03 AM

Page 1

Work Order ID: 66228

Parent Item: D4154-041

Parent Item Name: Wearplate Assembly



Start Date: 2/08/11

Required Date: 2/22/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.09.21 new issue DD verf:EC
10.11.04 added DT9684 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4154-1

Manufactured

No

100

Each

6.0000

1

4



Plate

B66173 x2

Location

Loc Qty

Loc Code

WA

6

65079

6

D4155-1

Manufactured

No

100

Each

11.0000

1

4



Bar

Location

Loc Qty

Loc Code

ST

2

60976

2

WA

9

62709

1

65080

8

EL 11-4-7

EL 11-4-7

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

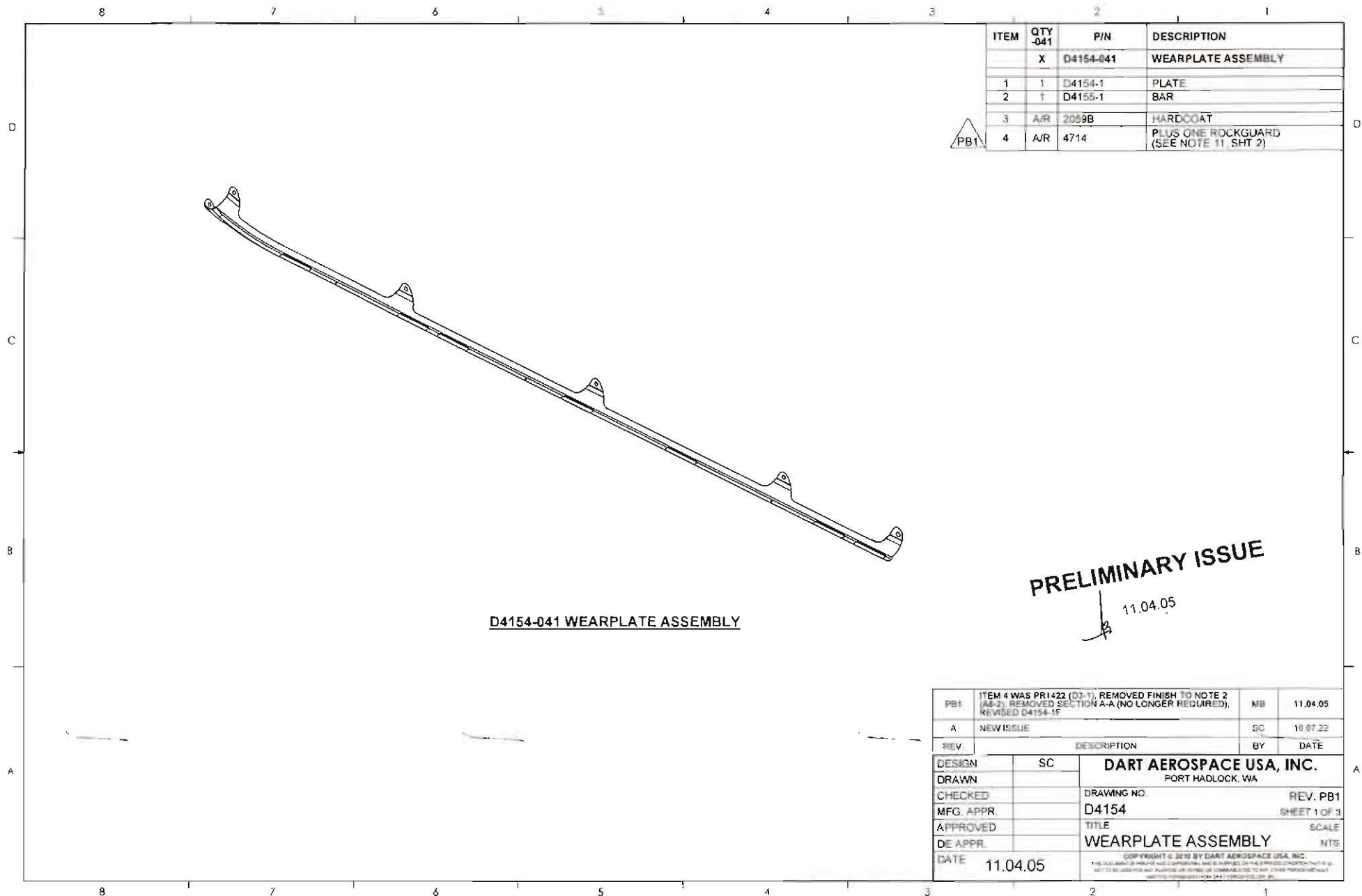
ITEM	QTY	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2050B	HARDCOAT
4	A/R	PR 1422	SEALANT (SEE NOTE 11, SHT 2)

SHOP COPY
RETURN TO:
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66228
CZ11/02108

D4154-041 WEARPLATE ASSEMBLY

RELEASED
2010-09-15

A	NEW ISSUE	SC	10.07.22
REV	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4154	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	MT5
DATE	10.07.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS RECOGNITION THAT IT IS NOT TO BE USED FOR REPRODUCTION OR FOR ANY OTHER PURPOSES WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>	



ITEM	QTY -041	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2)

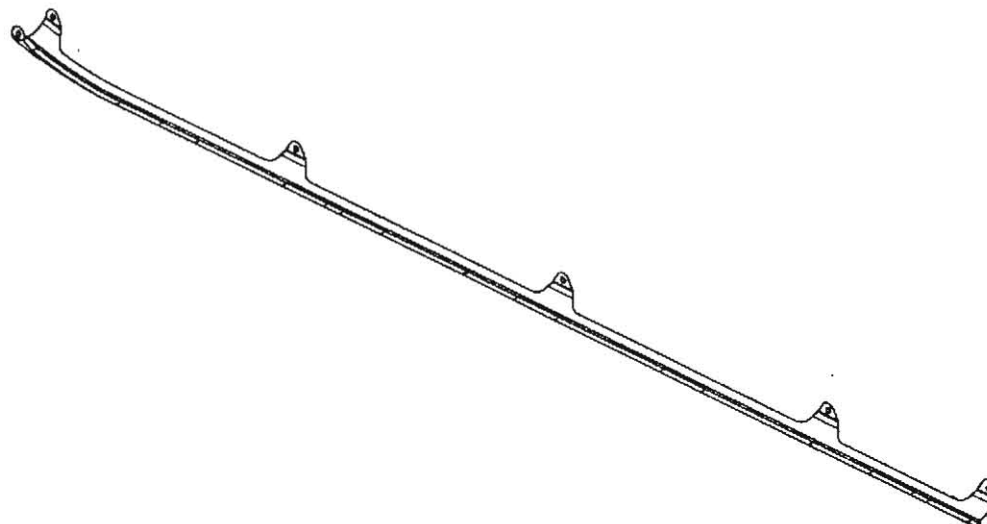
PB1

PRELIMINARY ISSUE

11.04.05

PB1	ITEM 4 WAS PRI 422 (D3-1), REMOVED FINISH TO NOTE 2 (AS-2), REMOVED SECTION A-A (NO LONGER REQUIRED), REVISED D4154-1F	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN		DRAWING NO.	REV. PB1
CHECKED		D4154	SHEET 1 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		WEARPLATE ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS THE PROPERTY OF DART AEROSPACE USA, INC. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION FROM DART AEROSPACE USA, INC.	
DATE	11.04.05		

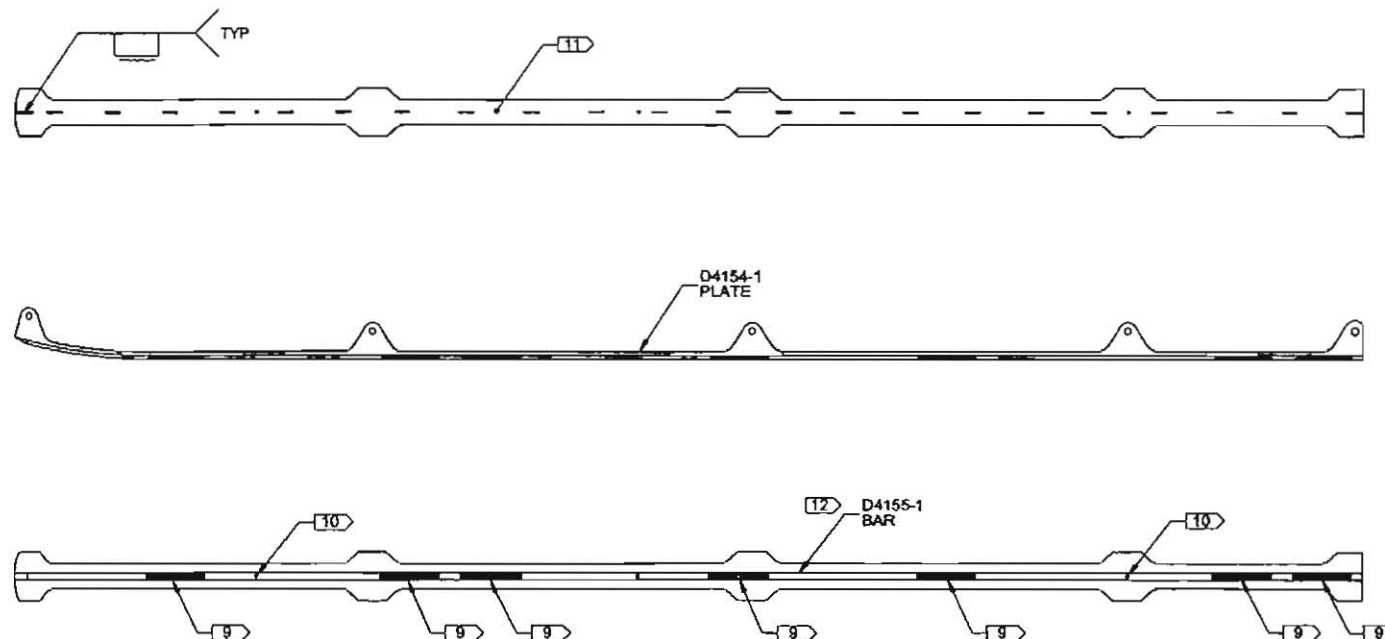
ITEM	QTY	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	20596	HARDCOAT
4	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2)



D4154-041 WEARPLATE ASSEMBLY

RELEASED
2011-04-12
WMP

B	ITEM 4 WAS PR1422 (03-1); REMOVED FINISH TO NOTE 2 (AS-2); REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1F		MB	11.04.05
A	NEW ISSUE		SC	10.07.22
REV.	DESCRIPTION		BY	DATE
DESIGN	SE	DART AEROSPACE USA, INC.		
DRAWN	5	PORT HADLOCK, WA		
CHECKED	HP	DRAWING NO.	REV. B	
MFG. APPR.	HP	D4154	SHEET 1 OF 3	
APPROVED	HP	TITLE	SCALE	
DE APPR.	HP	WEARPLATE ASSEMBLY	NTS	
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D4154-041 WEARPLATE ASSEMBLY

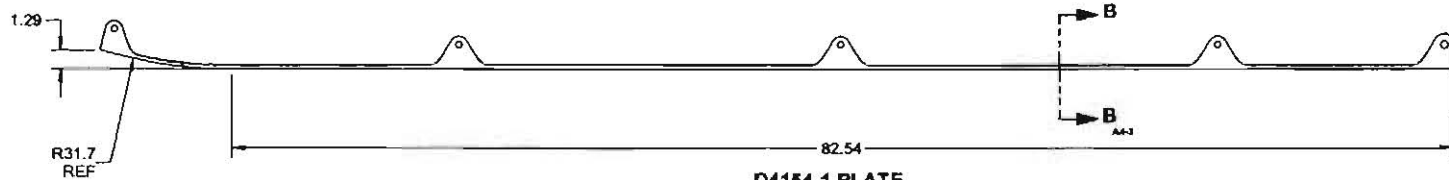
RELEASED
2011-04-13

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 6.88 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
- 10) TRANSFER DRILL $\phi 0.188$ HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D4154	SHEET 2 OF 3
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	WEARPLATE ASSEMBLY	NTS
DATE	11.04.05	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC.	

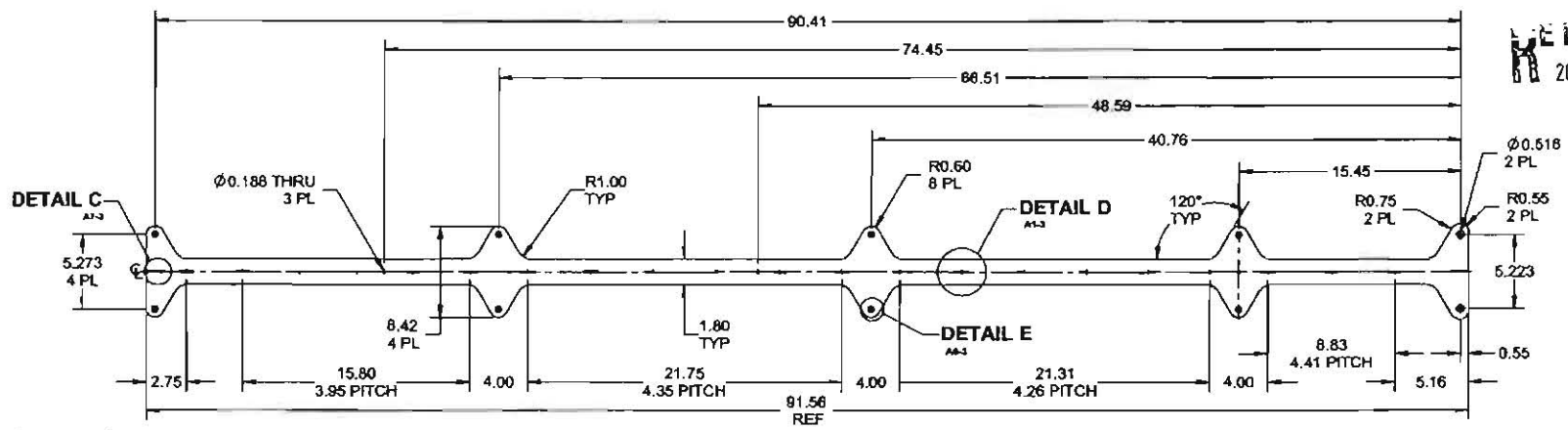
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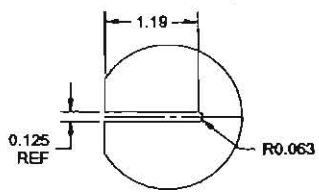
D4154-1 PLATE
(MAKE FROM D4154-1P)

66228

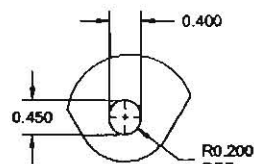
RELEASED
2011-04-13



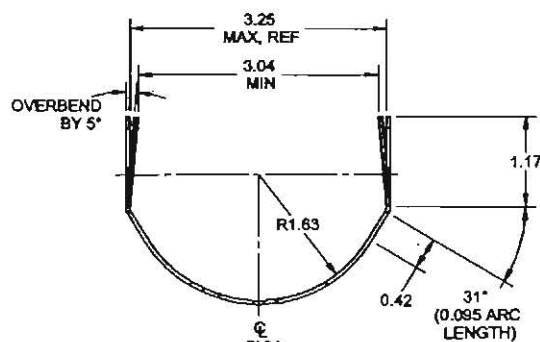
D4154-1F FLAT PATTERN



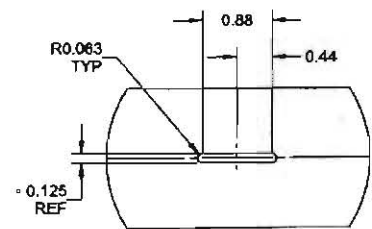
DETAIL C
END SLOT DETAIL, 2 PL



DETAIL E
SLOT DETAIL TYP



SECTION B-B



DETAIL D
SLOT DETAIL TYP

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5613 OR 5624 OR ASTM A240 OR ASME SA240
18 GAUGE 0.050 THICK (REF, DART SPEC. M304S18GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.85 lbs

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4154	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

